

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027872**Date Inspected:** 27-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Andrew Keech**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI attended a group meeting and there was an informational discussion of the progress of the UT examinations of the Electro Slag Welds (ESW). The QAI was informed that the contractor's currently approved Ultrasonic Testing (UT) procedure is under revision regarding the identification of planar (fusion related) indications. The QAI was informed that there are transverse cracks inherent to the ESW process and those indications should be mapped for the Engineer's evaluation of the welds. The QAI was informed that a revision to the contractor's approved UT procedure is under discussion and direction will be provided when the procedural revisions have been agreed upon.

The QAI was tasked with scanning Electro Slag Weld (ESW) weld H. The QAI noted that during the Ultrasonic Testing (UT) examination, multiple indications were observed. The QAI noted that these indications are located while performing scanning pattern E and generally appear to have a transverse planar orientation. The QAI noted that the weld cap is not ground flush. The UT inspection was performed using 70 degree shear wave from face B. The indications did not have a rating that qualifies as rejectable or recordable according to AWS D1.5 2002. The QAI noted that the inspected area contains indications that have been identified by the Quality Control (QC) inspections previously conducted. The inspection of this weld was stopped due to excavations of ESW F, face B, which is in the same compartment as this weld. The QAI noted that grinding and carbon arc gouging of the ESW was being performed by the contractor and there were unsafe conditions to continue the inspection of this weld.

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Summary of Conversations:

The QAI relayed the status of the UT inspections to the QAI Lead Bill Levell and Danny Reyes. There were other conversations between the QAI and ABF personnel regarding the access to welds and repairs in progress. The QAI did not monitor any welding or repairs during this shift. The QAI was informed that there will be a joint meeting regarding the ESW examinations, scheduled for tomorrow morning. Except as described above, there were no other notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
